

Work Order ID 143380

Tuesday, March 15, 2016 11:41:55 AM

143380

Page 1

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.
Start Date: 3/25/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/29/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date **MAR 15 2016** Tooling: Date:
QC: Date: SPC (Y/N): Date:
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043

CH0006

CH6007

ECN-~~570~~
16-514

N/A MLJ
MAY 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.
Start Date: 3/25/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/29/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	HandFinishing	0.00							
110	HandFinish	Memo							
Hand Finishing	1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/RSikaflex-241/-291 Expiry date:	0.03							
	2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/RSikaflex-241/-291 Expiry date:								
	3-Remove "T" pins once sikaflex is dry.								
	4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/RLPS Procyon								

★
PER
Attached
DSI 9733

Handwritten signature/initials

(X6) AN 5C-6A / M130622 bolts
(X4) AN 5C-7A / M132123 bolts
(X10) NAS 1149C0563R / M131697 (washers)

Handwritten signature/initials

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

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DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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143380

D412-742-043

Required Date: 3/29/2016

Required Qty: 1.00

Comments:

IPP Rev A	05.10.13	New Issue	KJ/JLM	
IPP Rev	06.02.13	ECN 773 dwg @ rev.D	EC	
IPP Rev:C	07-05-28	As per Rev F	JLM	
IPP Rev:D	07-12-04	ECN 1072	DD verified by:JLM	
IPP Rev:E	08-09-08	ecn 08-510	DD verified by:EC	IPP Rev:F
	11.11.01	as per DSI9517 REV.B	DD verified by:EC	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021		Manufactured	No				Each	0.0000		1			
D3391-021 Fwd Tube Assembly													
D3391-023		Manufactured	No			110	Each	0.0000	1	1			
D3391-023 Mid Tube Assembly													
D3391-025		Manufactured	No			110	Each	1.0000	1	1			
D3391-025 Aft Tube Assembly													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FG			1						
					112712		1						
AN3C4A		Purchased	No			110	Each	961.0000	24	24			
AN3C4A Bolt													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FG			20						
					122814		20						
				FP001			101						
					M133440		7						
					M134055		94						
				ST350			840						
					M134134		40						
					M134396		800						

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 143380

143380

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.

Start Date: 3/25/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

100.0000

10

~~10~~ 4 ~~20~~

AN3C6A

Bolt

**

~~20~~ 16/05/16

Location

Loc Qty

Loc Code

CA

31

m128704

31

FG

10

122416

10

FP001

22

m133363

5

m133990

17

ST338a

32

m128769

26

m133077

6

11134502

x2

x2

ST349

5

m132767

4

m133694

1

AN3C7A

Purchased

No

110

Each

567.0000

4

4

AN3C7A

Bolt

**

~~20~~ 16/05/16

Location

Loc Qty

Loc Code

FG

10

122141

10

FP001

52

m125709

52

OVER002

400

m125709

400

ST349

105

m125709

105

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 143380

143380

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.

Start Date: 3/25/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

4,273.000

38

~~38~~ 28 *ell*

NAS1149C0332R

WASHER

ell 16/03/10

Location

Loc Qty

Loc Code

FP001

3062

m132262

4

m132930

1004

m134063

1838

m134073

216

GA

32

m133284

32

ST266

1179

m133284

679

m134474

500

X 28

D4095-041

Manufactured

No

110

Each

7.0000

1

1

D4095-041

Wearplate Fwd

ell 16/05/10

Location

Loc Qty

Loc Code

FP001

1

138304

1

FP002

6

136547

1

139765

5

X 1

D4095-043

Manufactured

No

110

Each

6.0000

1

1

D4095-043

Wearplate Aft

ell 16/05/10

Location

Loc Qty

Loc Code

FP002

6

134429

1

138323

1

140674

4

13139766

X 1

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Description Work Order Deviation		Disposition			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Parent Item Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.

Start Date: 3/25/2016

Required Date: 3/29/2016

Start Qty: 1.00

Required Qty: 1.00

D4095-045

Manufactured No

110

Each

6.0000

1

1

D4095-045

Wearplate Center

el 16/03/10

Location

Loc Qty

Loc Code

FP002

6

140675

6

xl

DQA: _____ Date: _____



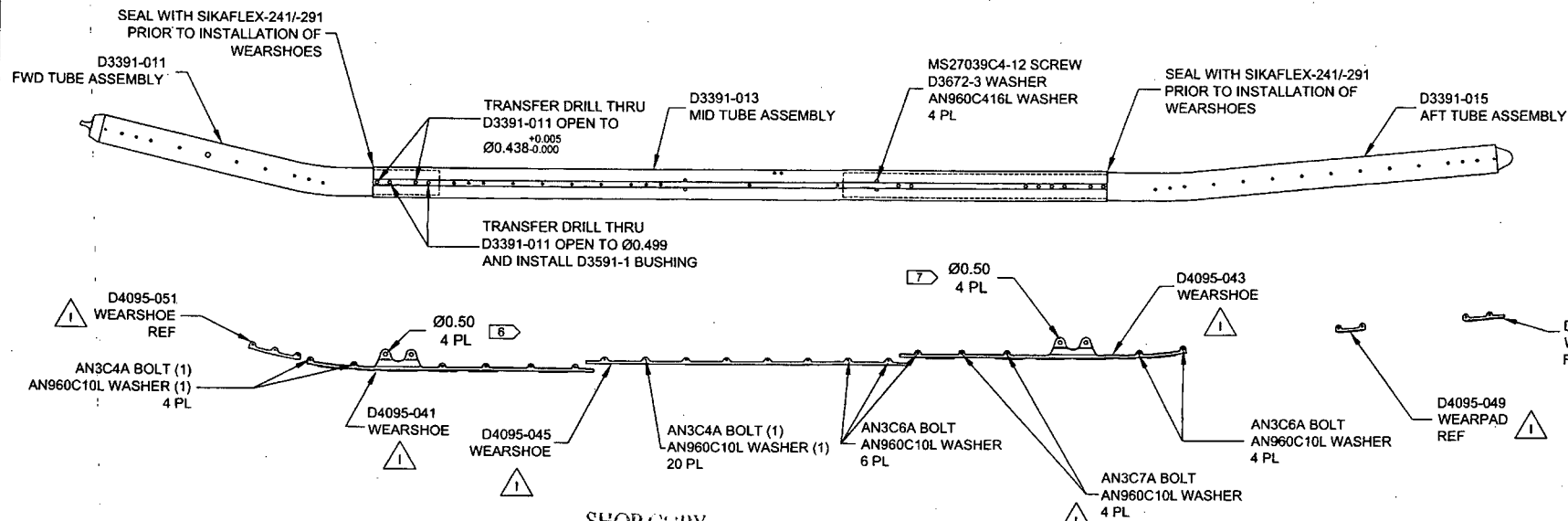
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							Completed By		
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143380 ML5
16-03-15

RELEASED
2011-11-04
ECN# 11-662

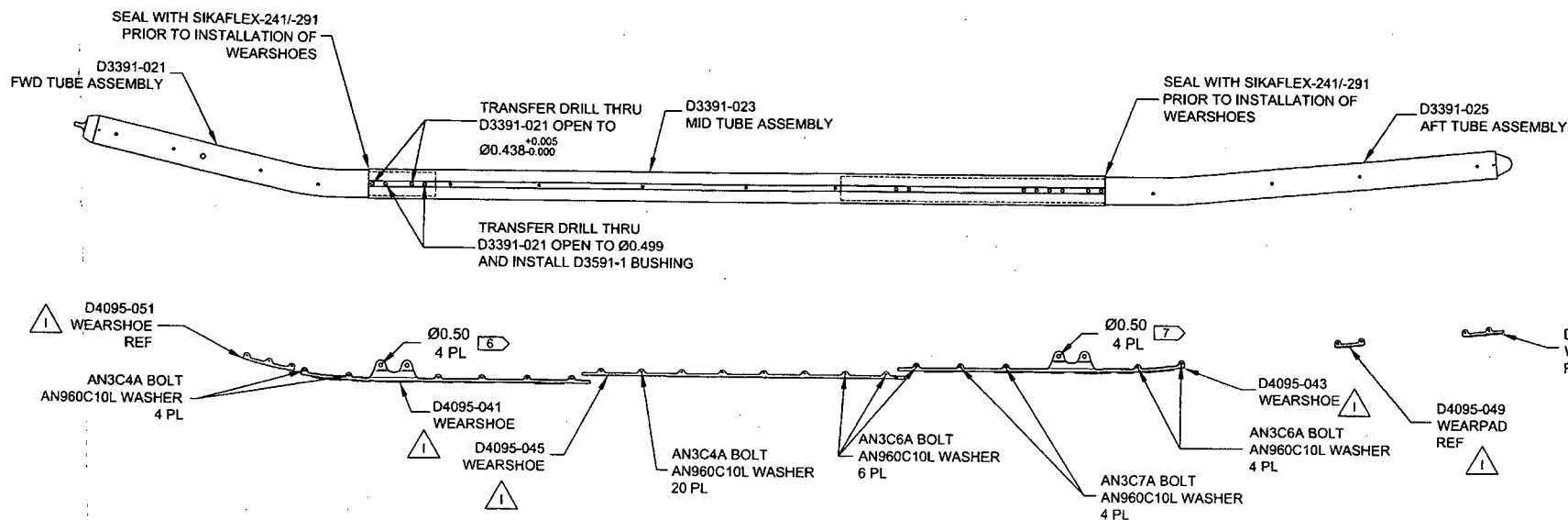
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.	DS	D3391	SHEET 1 OF 8
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

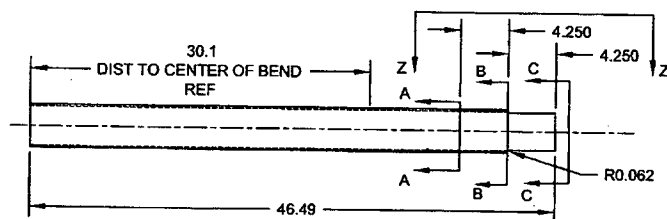
QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

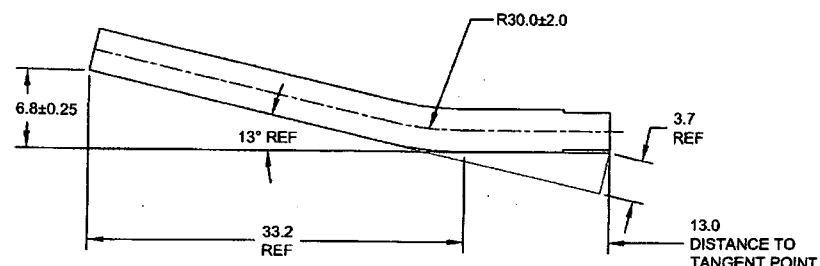
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

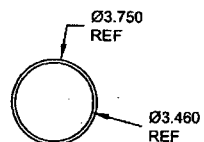
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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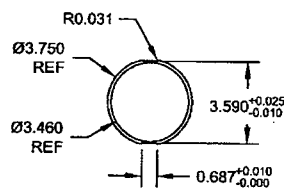
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



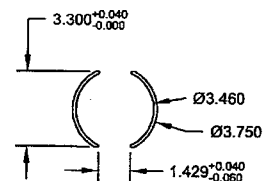
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



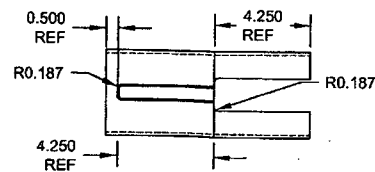
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



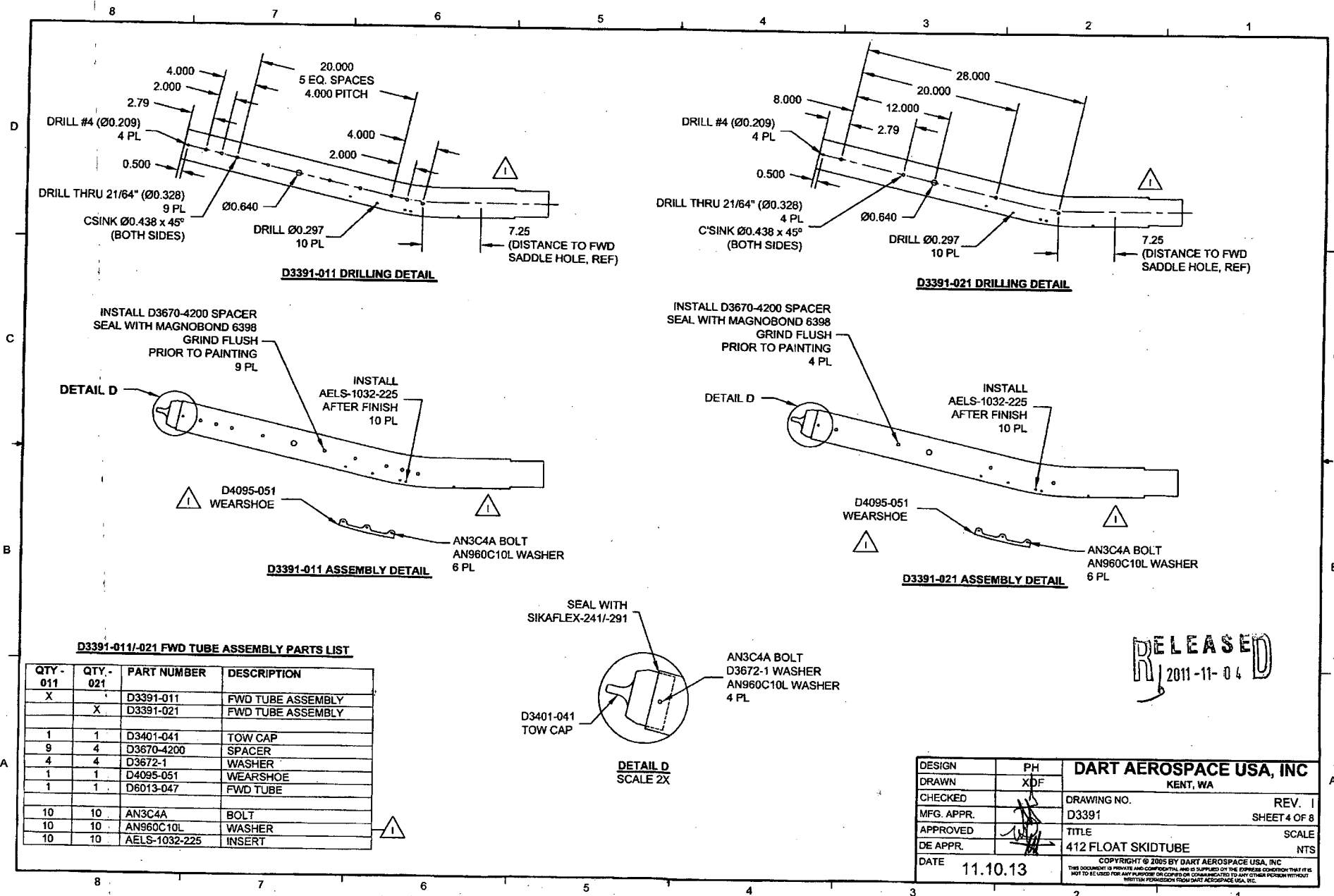
SECTION C-C
SCALE 2X

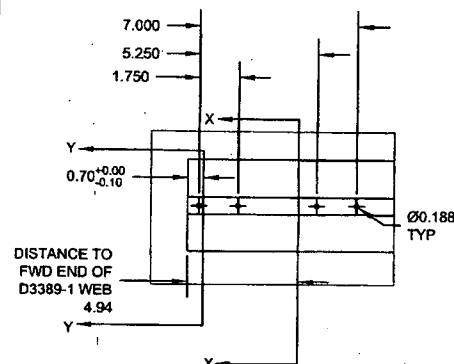


VIEW Z-Z
SCALE 2X

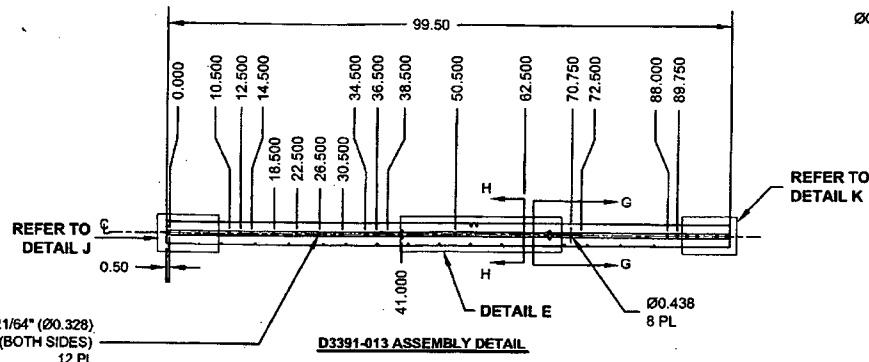
RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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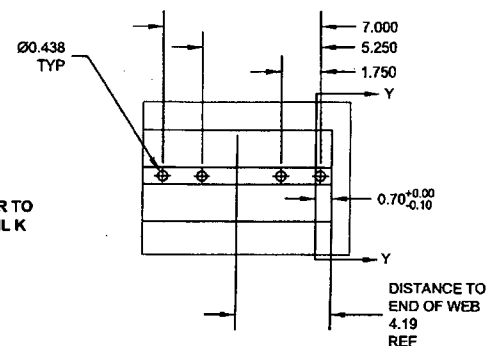




DETAIL J
SCALE 4X



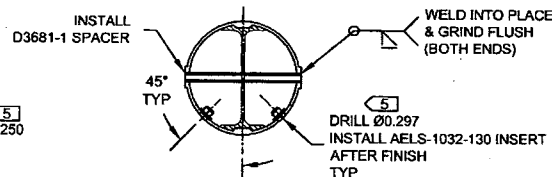
D3391-013 ASSEMBLY DETAIL



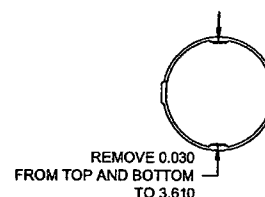
DETAIL K
SCALE 4X



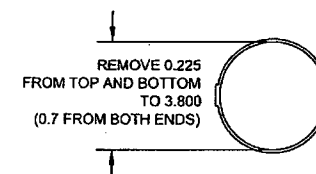
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



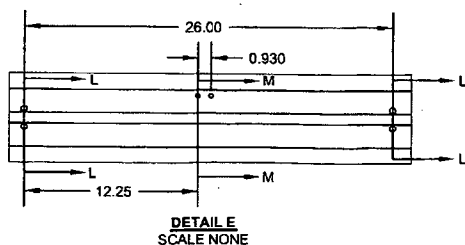
SECTION X-X
SCALE 5X



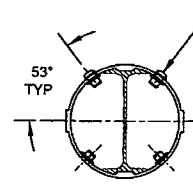
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

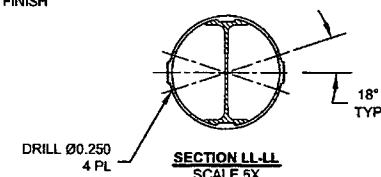
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E
SCALE NONE

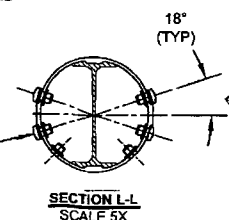


SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL

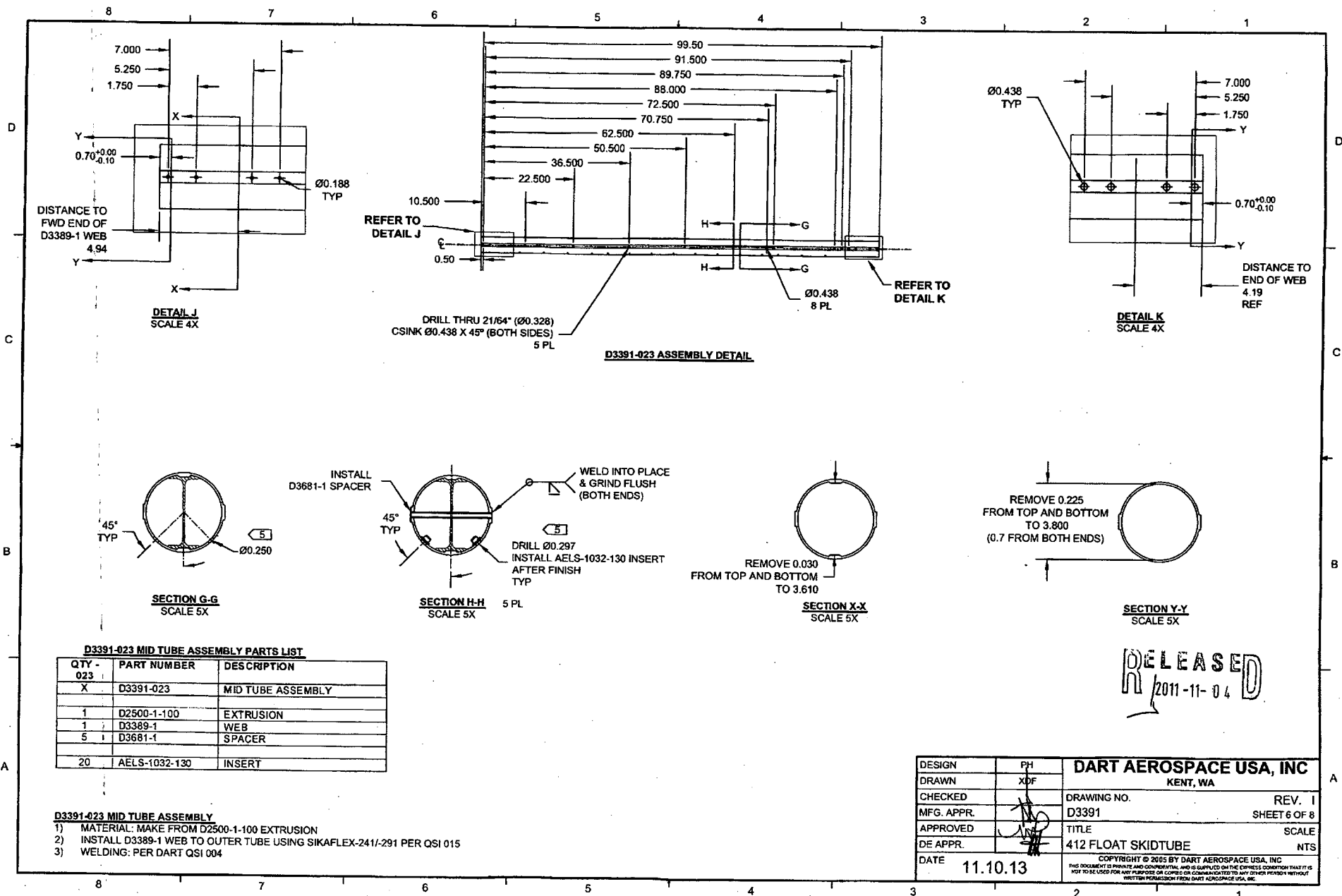


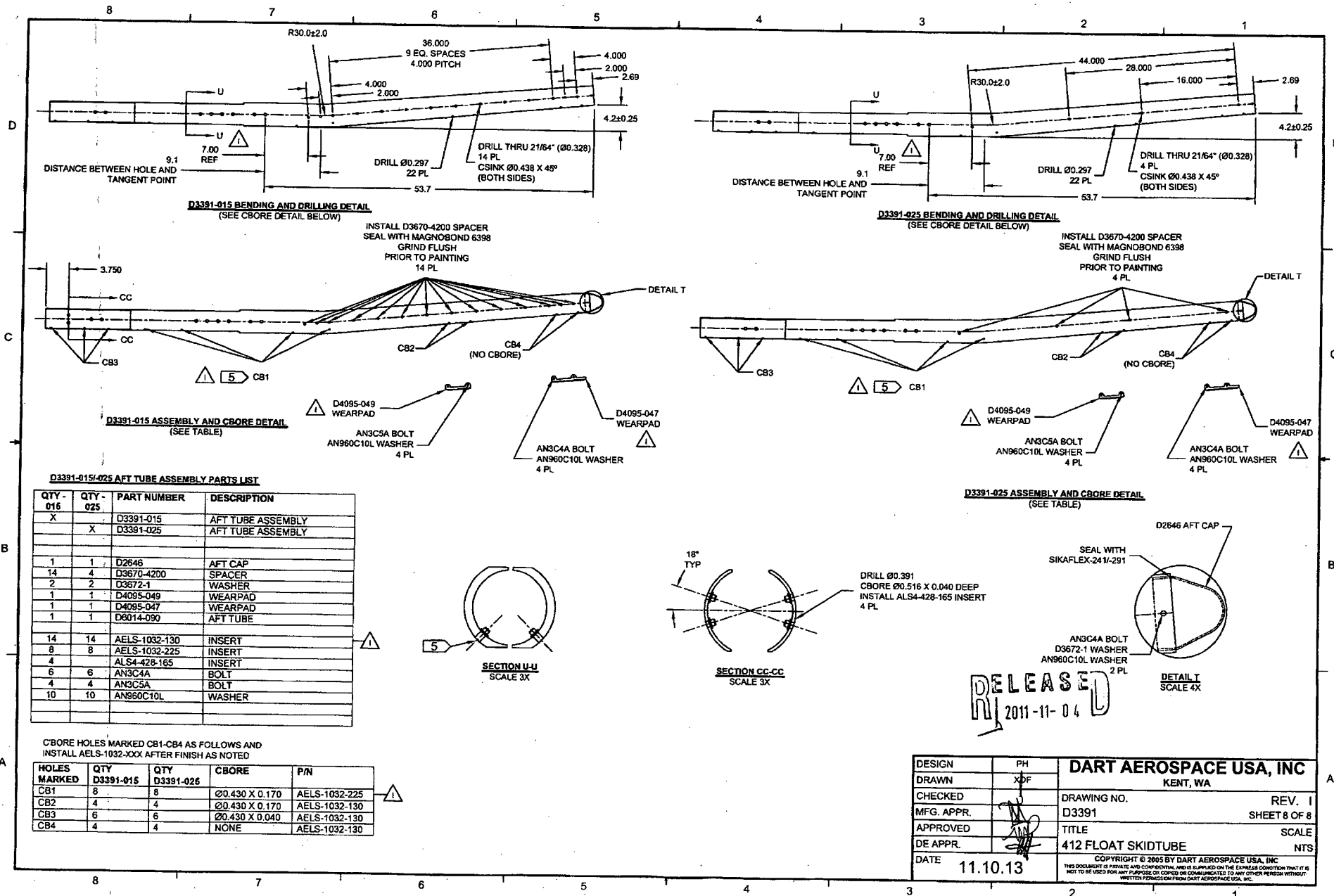
SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART.QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 4
REF FAA STC: SR01583SE
REF CANADIAN STC: SH05-37
REF EASA STC: EASA.IM.R.S.00126

1.0 PURPOSE

The purpose of this DART Service Instruction is to provide a repair procedure to replace spinning AELS-1032 inserts with MS21075L5 Floating Nut Plates on D412-742-011/-013 Float Skid tubes in locations where the D3391-013/-023 Mid Tube Assembly overlaps the D3391-015/-025 Aft Tube Assembly as shown in Figure 1.

This modification has been incorporated into D412-742-011 @ CHG008 and D412-742-013 @ CHG008

2.0 INSTALLATION

Note 1: Disassembly of the D3391-015/-025 Aft Tube Assembly from the D3391-013/-023 Mid Tube Assembly is required prior to completion of this repair. Disassemble in accordance with ICA-D12-742.

Note 2: When drilling holes for the Floating Nut Plate, DART recommendation is to use a Nut Plate Drill Jig to ensure drilled holes are well aligned and square for ease of installation.

- 2.1 Drill out AELS-1032 Inserts (Qty 10) located in D3391-015/-025 Aft Tube Assembly using a $\varnothing 0.375$ drill in locations shown in Figure 1. With reference to Note 2, add additional $\varnothing 0.129$ countersunk holes (Qty 2) per Detail A.
- 2.2 Increase the diameter of affected thru holes in D3391-013/-023 Mid Tube Assembly with a $\varnothing 0.375$ drill bit, as shown in Figure 1.
- 2.3 Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.4 Install MS21075L5 Nut Plate (Qty 10) using MS20801AD4W4 (Qty 12) in the six (6) most forward holes and MS20801AD4W9 (Qty 8) in the four (4) aft holes. It is acceptable to replace MS20801AD4 rivets with longer or shorter rivets as required.
- 2.5 Increase diameter of affected wearpad holes on D4095-043/-045 to $\varnothing 0.375$
- 2.6 Re-install D3391-015/-025 Aft Tube Assembly in accordance with ICA-D412-742 Section 32.9. Install D4095-043/-045 Wearshoes using AN5C7A Bolts (Qty 10) and NAS1149C0532R Washers (Qty 10) in locations corresponding to this modification.

A	NEW ISSUE	WM	15.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	WM		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	NIA	DSI 9733	SHEET 1 OF 3
APPROVED	CH	TITLE	SCALE
DE APPR.	CH	SKIDTUBE INSERT REPAIR	NTS
DATE	15.11.27	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

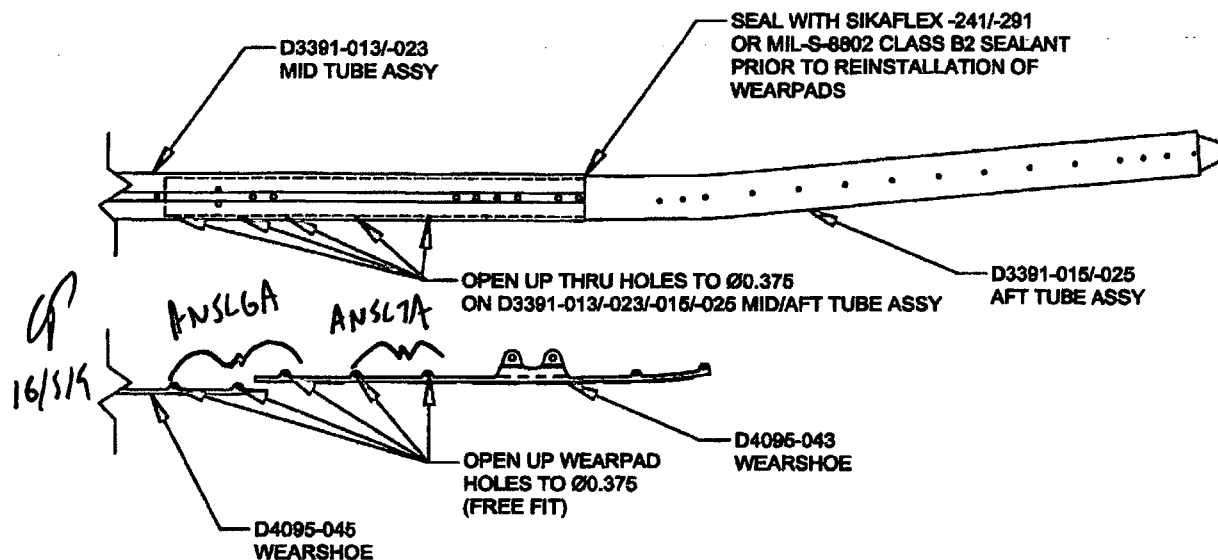
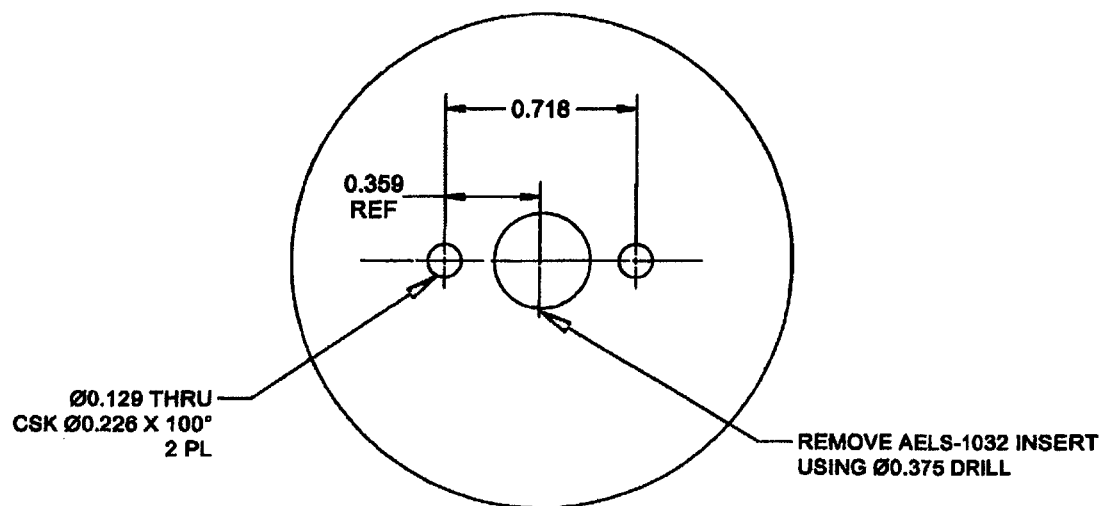


FIGURE 1 - AFFECTED LOCATIONS

(Aft section of D412-742-XXX Assy shown)



DETAIL A

(10 PLACES)

DESIGN	AP	DART AEROSPACE USA, INC EUGENE OREGON	
DRAWN	WM		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9733	SHEET 2 OF 3
APPROVED	DN	TITLE	SCALE
DE APPR.	ST	SKIDTUBE INSERT REPAIR	NTS
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3.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
10	DSI9733-011	SKIDTUBE REPAIR KIT
12	AN5C7A	BOLT
12	MS20601AD4W4	RIVET, BLIND
8	MS20601AD4W9	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0532R	WASHER

⇒ (4) AN5C7A

(6) AN5C6A

GP 15/5/5

4.0 WEIGHT AND BALANCE

There is negligible weight and balance change associated with this modification.

DESIGN	AP	DART AEROSPACE USA, INC	
DRAWN	WM	EUGENE, OR	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9733	SHEET 3 OF 3
APPROVED	DM	TITLE	SCALE
DE APPR.	SH	SKIDTUBE INSERT REPAIR	NTS
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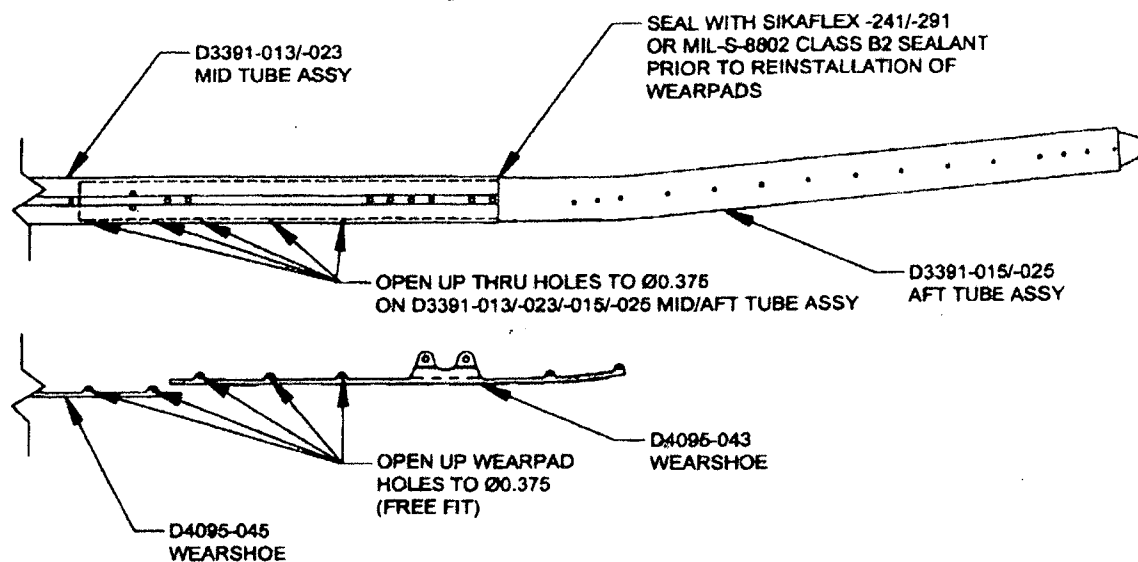
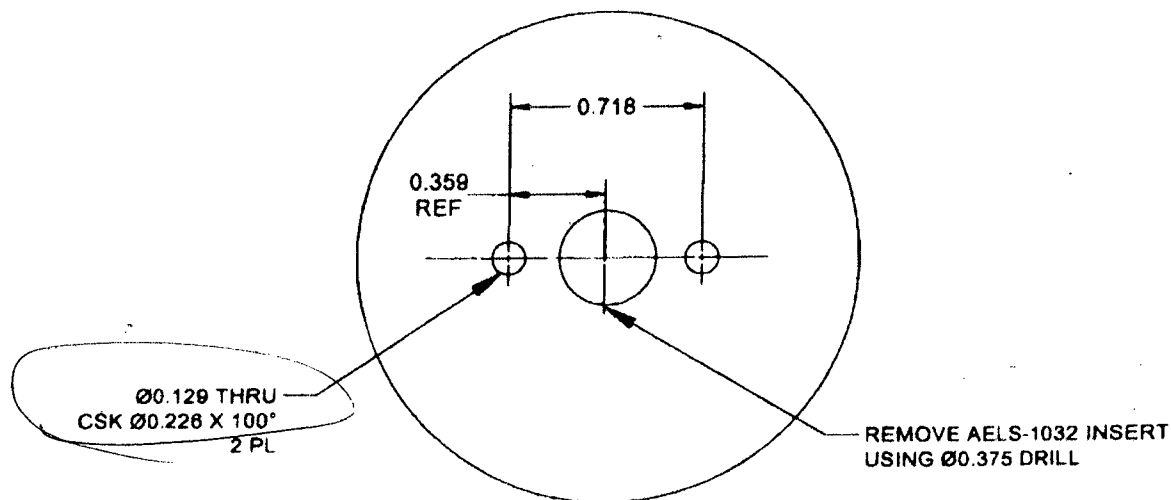


FIGURE 1 - AFFECTED LOCATIONS

(Aft section of D412-742-XXX Assy shown)



DETAIL A

(10 PLACES)

DESIGN	AP	DART AEROSPACE USA, INC EUGENE OREGON	
DRAWN	WM		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9733	SHEET 2 OF 3
APPROVED	DN	TITLE	SCALE
DE APPR.	W	SKIDTUBE INSERT REPAIR	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. E AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 4

REF FAA STC: SR01583SE
REF CANADIAN STC: SH05-37
REF EASA STC: EASA.IM.R.S.00126

1.0 PURPOSE

The purpose of this DART Service Instruction is to provide a repair procedure to replace spinning AELS-1032 inserts with MS21075L5 Floating Nut Plates on D412-742-011/-013 Float Skidtubes in locations where the D3391-013/-023 Mid Tube Assembly overlaps the D3391-015/-025 Aft Tube Assembly as shown in Figure 1.

This modification has been incorporated into D412-742-011 @ CHG008 and D412-742-013 @ CHG008

2.0 INSTALLATION

Note 1: Disassembly of the D3391-015/-025 Aft Tube Assembly from the D3391-013/-023 Mid Tube Assembly is required prior to completion of this repair. Disassemble in accordance with ICA-D12-742.

Note 2: When drilling holes for the Floating Nut Plate, DART recommendation is to use a Nut Plate Drill Jig to ensure drilled holes are well aligned and square for ease of installation.

- 2.1 Drill out AELS-1032 Inserts (Qty 10) located in D3391-015/-025 Aft Tube Assembly using a $\varnothing 0.375$ drill in locations shown in Figure 1. With reference to Note 2, add additional $\varnothing 0.129$ countersunk holes (Qty 2) per Detail A.
- 2.2 Increase the diameter of affected thru holes in D3391-013/-023 Mid Tube Assembly with a $\varnothing 0.375$ drill bit, as shown in Figure 1.
- 2.3 Touch up affected areas with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.4 Install MS21075L5 Nut Plate (Qty 10) using MS20801AD4W4 (Qty 12) in the six (6) most forward holes and MS20801AD4W9 (Qty 8) in the four (4) aft holes. It is acceptable to replace MS20801AD4 rivets with longer or shorter rivets as required.
- 2.5 Increase diameter of affected wearpad holes on D4095-043/-045 to $\varnothing 0.375$
- 2.6 Re-install D3391-015/-025 Aft Tube Assembly in accordance with ICA-D412-742 Section 32.9. Install D4095-043/-045 Wearshoes using AN5C7A Bolts (Qty 10) and NAS1149C0532R Washers (Qty 10) in locations corresponding to this modification.

A	NEW ISSUE	WM	15.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	WM		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	NIA	DSI 9733	SHEET 1 OF 3
APPROVED	CAF	TITLE	SCALE
DE APPR.		SKIDTUBE INSERT REPAIR	NTS
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3.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
1	DSI9733-011	SKIDTUBE REPAIR KIT
10	AN5C7A	BOLT
12	MS20601AD4W4	RIVET, BLIND
8	MS20601AD4W9	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0532R	WASHER

132123 (4)

4.0 WEIGHT AND BALANCE

There is negligible weight and balance change associated with this modification.

DESIGN	AP	DART AEROSPACE USA, INC	
DRAWN	WM	EUGENE, OR	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9733	SHEET 3 OF 3
APPROVED	DM	TITLE	SCALE
DE APPR.	SH	SKIDTUBE INSERT REPAIR	NTS
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Change Record

PAGE 1 OF 1

Part Number: D412-742-043

Description: REPLACEMENT FLOAT SKIDTUBE

[illegible]